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Memorandum

April 6, 2007

To: Bruce Chrisman
From: William Griffing 
Subject: Revised FESHM Chapter 5031.2 – Inert Gas Trailer Connections and Onsite Filling Guidelines

FESHM chapter 5031.2, Inert Gas Trailer Connections and Onsite Filling Guidelines, has been revised to reflect current operations, and to incorporate lessons learned from operational events. It has been reviewed sitewide and comments have been addressed by the Mechanical Safety Subcommittee.

After final approval, please return this approval page to Elizabeth Bancroft at MS119 for posting on the web.

Encl.

Recommended for Approval:

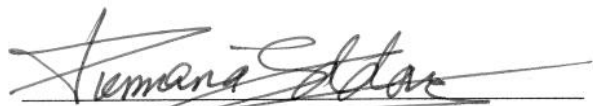


Bruce Chrisman

4/10/07

Date

Approved:



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4/10/07

Date

INERT GAS TRAILER CONNECTIONS AND ONSITE FILLING GUIDELINES

INTRODUCTION

This chapter outlines recommended system configuration for tube trailer connections for inert, non-flammable gases. This chapter also outlines the recommended training and documentation for Fermilab personnel who regularly engage in refilling. Inert gases are non-flammable and would include helium, nitrogen, argon or dry air. This chapter specifies required fittings and components for helium tube trailer manifolds and high pressure hose assemblies which are used for the filling of reduced pressure systems from high pressure helium tube trailers. This chapter specifies the recommended guidelines for onsite helium tube trailer refilling by vendors.

PHILOSOPHY

The philosophy of the connection from the tube trailer shall be to minimize the amount of high pressure piping and use flexible hose or tubing in the low pressure piping. In the event flexible hose or tubing exists, the low pressure ends shall be restrained to prevent "whipping."

DEFINITIONS

Whipping - dangerous unconstrained motion of the end of a high pressure flexible hose which is discharging high pressure inert gases to atmospheric pressure.

Driveaway accident - driving a tube trailer away without removing the connection hose from the manifold thereby damaging the connection hose, manifold and fittings.

Safety chain - any link chain, safety strap, or reinforced cable which can withstand a design load of 1400 lb.

RESPONSIBILITIES

It is the responsibility of the division/section transferring or receiving inert gases at high pressure to assure compliance with this chapter.

MANIFOLD REQUIREMENTS

Any Fermilab Owned Tube Trailer Manifold Used For Delivery Of Inert Gases To Other Inert Gas Systems Shall Have:

1. All hard piped branch supply valves and suitably rated male high pressure supply fittings. For helium trailers, there must be at least one male high pressure O-ring fitting #53T-5-SS supplied by Combination Pump Valve Company (CPV).

2. A permanently attached pressure rated protective cap for the CPV high pressure O-ring fitting #53T-5-SS (Union nut 50N-5 bronze, blank fitting #1048-5 Stainless Steel).
3. A "safety chain" termination no further than 12" away from the male high pressure fitting for reversed flow situations.
4. A suitably rated accurate pressure gauge in the trailer manifold.
5. A suitably rated accurate temperature gauge in the trailer manifold.
6. A device to prevent a "Driveaway Accident" from causing personnel injury or serious system damage (e.g., wheel chocks, Hydraulic cut-off flag).

All piping systems associated with delivering pressurized gas from trailer manifolds must meet the requirements of FESHM 5031.1, "Pressure Piping Systems."

Any Fermilab Owned Tube Trailer Manifold Used For Delivery Of Inert Gas To Other Inert Gas Systems Shall Not Have:

1. A flexible hose or element attached directly to the inert gas tube trailer high pressure manifold.

Any Fermilab Owned Tube Trailer Manifold Used For Delivery Of Inert Gas To Other Inert Gas Systems May Have:

1. A hard piped pressure rated purge valve between the branch supply valve and suitably rated high pressure fitting.
2. Extra ports capped with pressure rated caps.

FLEXIBLE TUBING OR HOSE REQUIREMENTS

Any Flexible Tubing Or Hose For Connection Between Fermilab Owned Or Leased Tube Trailers And Other Inert Gas Systems Shall Have:

1. A suitably rated tubing or hose as the flexible element. If stainless steel is used, 316 is recommended for its resistance to chloride corrosion.

2. A "Safety Chain" which is solidly attached to the flexible hose, mounted within the last 12" of the low pressure end of the flexible hose. The "Safety Chain" shall be connected in such a manner that "whipping" will not loosen or remove the "Safety Chain" from either end termination.
3. End connectors rated for the highest system pressure.

Any Flexible Tubing Or Hose For Connection Between Fermilab Owned Or Leased Tube Trailers And Other Inert Gas Systems Shall Not:

1. Be attached directly (without a shut-off valve) to the inert gas tube trailer high pressure manifold.

Any Flexible Tubing Or Hose For Connection Between Fermilab Owned Or Leased Tube Trailers And Other Inert Gas Systems May Have:

1. Hard piped pressure rated purge valve adapter (see figure #1, AV2 or AV3).
2. Non-standard female high pressure rated fittings which are connected to alternate delivery systems.

RECOMMENDED MANIFOLD CONFIGURATION FOR HELIUM TRAILERS

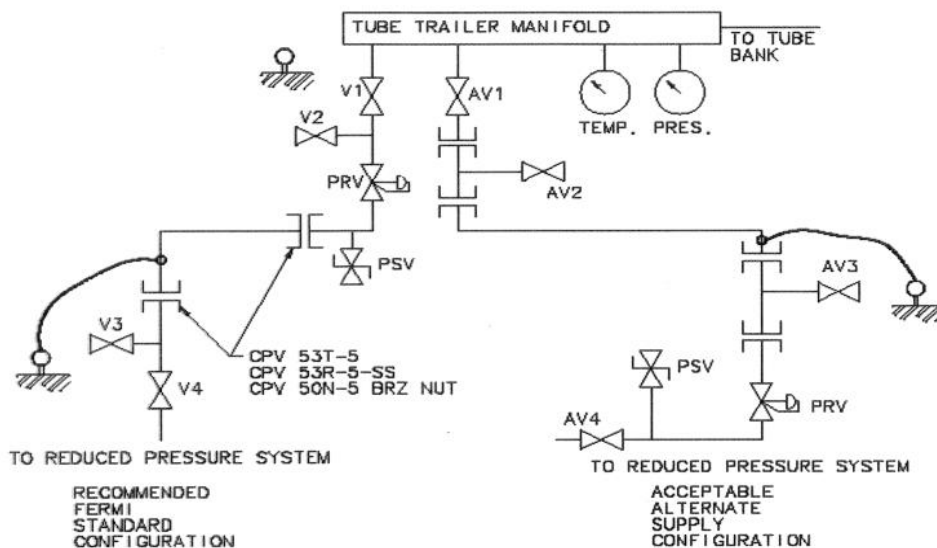


FIGURE #1

RECOMMENDED TRAINING AND DOCUMENTATION FOR FERMILAB PERSONNEL WHO REGULARLY ENGAGE IN REFILLING PROCEDURES

It is recommended that personnel who engage in the refilling of pressure systems from Fermilab owned or leased trailers be trained on an annual basis on the proper refilling procedures for their respective systems. It is also recommended that a log book of training be maintained for the purpose of documenting who has received this training and the date. Documentation should include the name of the trained individual, the date of training, and the signature of the division/section head or qualified designee.

SUGGESTED INERT GAS TUBE TRAILER VENDOR ONSITE DELIVERY PROCEDURES FOR FILLING CLEAN INERT GAS HIGH PRESSURE SYSTEMS.

Any vendor inert gas tube trailer should have a delivery hose with a safety chain attached to the low pressure end which is capable of attaching to a safety chain termination located within 12" of the receiving fitting. Any vendor delivering inert gas

to Fermilab high pressure systems should follow this procedure:

1. Ensure all tube isolation valves are closed.
2. Connect hose - attach safety chains.
3. Ensure fitting is not leaking by cracking V-1, pressurizing the line, and closing V-1.
4. Open V-3 and purge line, leaving a slight positive pressure. Repeat cracking, closing and purging one more time.
5. Close V-3, open trailer tube isolation valves. Open V-2 and start fill.
6. When Fermilab trailer has been filled, shut V-2 and all tube isolation valves on trailers that were opened.
7. Bleed down hose through V-3.
8. Disconnect hose, remove safety chains and cover fitting with Fermilab supplied cap.

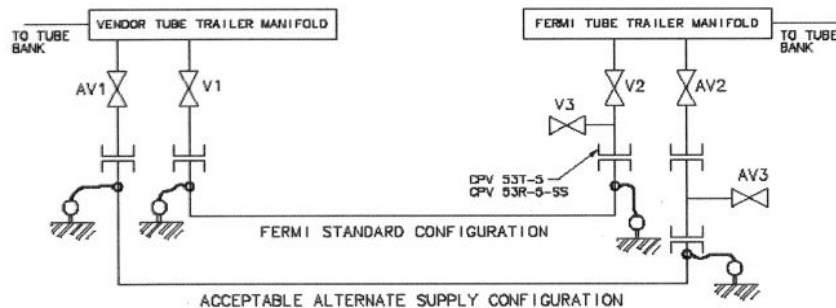


FIGURE #2